

Date: Friday, 11/18/2005 3:16:28 PM
User: Linda Lacelle

Process Sheet

Customer : CU-DAR001 Dart Helicopters Services	Drawing Name : SADDLE FITTING, FWD (OUTBOARD/INBOARD)
Job Number : 24837	
Estimate Number : 10530	
P.O. Number : N/A	Part Number : D2571
This Issue : 11/18/2005 S.O. No. : N/A	Drawing Number : D2571 REV D
Prsht Rev. : NC	Project Number : N/A
First Issue : N/A Type : MACHINED PARTS	Drawing Revision : D
Previous Run : 24433	Material : N/A
Written By : SEE COMMENT BELOW	Due Date : 12/20/2005 Qty: 12 Um: Each
Checked & Approved By : SEE COMMENT BELOW	
Comment : Est: 1 02.10.02 Re-format; Change to Dwg Rev. D & incorporated D2572KJ	

Additional Product

Job Number:



Seq. #:	Machine Or Operation:	Description :
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10	D6101007	7075-T7351 8.25X7.75X2.5
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Comment: Qty.: 1.0000 Each(s)/Unit Total: 12.0000 Each(s)
7075-T7351 8.25X7.75X2.5
Make from D6101-007 billet for D2571
Ensure that grain is along 7.75" length
Batch No: B25205 M8 06/01/21 12

20	HAAS1	HAAS CNC VERTICAL MACHINING #1
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Comment: HAAS CNC VERTICAL MACHINING #1
Program Batch No. 24837 Double check by: S 06/01/21

- 1-Machine Step No 1 per Folio FA051 and inspect per attached Dimension Sheets
- 2-Machine Step No 2 per Folio FA051 and inspect per attached Dimension Sheets
- 3-Machine Step No 3 per Folio FA051 and inspect per attached Dimension Sheets
- 4-Deburr and remove all machining marks M8
- 5-Tumble to remove sharp edges. N/A

M8 06/01/22
M8 06/01/22
M8 06/01/22
S.G 06/01/24
12

30	MILLING CONV.	CONVENTIONAL MILLING MACHINE
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Comment: CONVENTIONAL MILLING MACHINE
Machine keyway as per dwg D2571 & D2572

S.G/M8 06/01/22

40	QC2	INSPECT PARTS AS THEY COME OFF MACHINE
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Comment: INSPECT PARTS AS THEY COME OFF MACHINE

S.G/M8 06/01/22 12

Dart Aerospace Ltd

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____
 QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Date: Friday, 11/18/2005 3:16:28 PM
User: Linda Lacelle

Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: SADDLE FITTING, FWD (OUTBOARD/INBOARD)

Job Number: 24837

Part Number: D2571

Job Number:



Seq. #:	Machine Or Operation:	Description :
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5.0

QC8

SECOND CHECK



5.1 06-01-27 12

Comment: SECOND CHECK

6.0

HAND FINISHING1

HAND FINISHING RESOURCE #1



Comment: HAND FINISHING RESOURCE #1

Acid etch and Alodine as per QSI 005 4.1

ml

06 01 30

12

7.0

POWDER COATING

POWDER COATING



Comment: POWDER COATING

Powder Coat White Gloss (Ref: 4.3.5.1) as per QSI 005 4.3

ml

06 01 30

12

8.0

QC3

INSPECT POWDER COAT/CHEMICAL CONVERSION



Comment: INSPECT POWDER COAT

CZ 06/01/31

12

9.0

PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Identify and Stock

Location: 372

CZ 06/01/31

12

10.0

DC

DOCUMENT CONTROL



Comment: DOCUMENT CONTROL

Inspection Level 21

545 06/02/01

(12)

SD

06/02/01

Job Completion



W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: 12 Date: 06/02/01
 QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

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Job Costing Report

Dart Aerospace Ltd.
Hawkesbury

Nov 17, 2005
03:30 pm

Work Order No	: 0024837	Department Code:	
Project Name	: D2571	Burden Flags	: NNNNNNN
Project For	: WK550	WO Status	: Open
Work Order Type	: Main	Invoice State	: Not Invoiced
Main WO Number	:	Invoice Date	:
House Part Number	: D2571	Invoice Number	:
Description	: Saddle, Fwd, Out	Invoice Amount	: 0.00
Manufactured	: Yes	Order Entry No	:
Amount Req'd	: 12	OE Value	: 0.00
Amount Done	: 0	Est Margin	: 0.000%
Start Date	: 11-17-05	Actual Margin	: 0.000%
Est Finish Date	: 12-20-05		
Act Finish Date	:		
Drawings Req'd	: No		
Ok for Approval	:		
Approval Rec'd	:	\$0 Posted to Finished Goods	

	Estimated	Actual	Var. %	Posted	To Post
Material Cost	0.00	0.00	0.00	0.00	0.00
Engineering Hours	0.00	0.00	0.00		
Engineering Cost	0.00	0.00	0.00	0.00	0.00
Production Hours	0.00	0.00	0.00		
Production Cost	0.00	0.00	0.00	0.00	0.00
Packaging Hours	0.00	0.00	0.00		
Packaging Cost	0.00	0.00	0.00	0.00	0.00
OverHead Hours	0.00	0.00	0.00		
OverHead Cost	0.00	0.00	0.00	0.00	0.00
CNC Hours	0.00	0.00	0.00		
CNC	0.00	0.00	0.00	0.00	0.00
Misc. Hours	0.00	0.00	0.00		
Misc.	0.00	0.00	0.00	0.00	0.00
Burden	0.00	0.00	0.00		
Total Cost	0.00	0.00	0.00		
Margin	0.000	0.000			
Selling Cost	0.00	0.00			

	Estimated	Actual
Labour Hrs/Amount Done	0.00	0.00
Profits/(Loss)	0.00	0.00

DART AEROSPACE LTD	Work Order:	24838
Description: Saddle, Fwd Outboard	Part Number:	D2571
Inspection Dwg: D2571 Rev. E		Page 1 of 1

Inspect dimensions highlighted on inspection sheet drawing D2571 Rev. E and record below:

				Recorded Actual Dimensions					
Dim	Min	Max	Go/No Go Gauge	1	2	3	4	By	Date
A	0.438	0.443	DT8682	✓	✓	✓	✓		
B	1.745	1.755		1.750	1.750	1.750	1.750		
C	3.495	3.505		3.500	3.500	3.500	3.501		
D	1.745	1.755		1.750	1.750	1.750	1.750		
E	7.990	8.010		8.002	8.003	8.002	8.003		
F	0.490	0.510		.502	.500	0.501	0.501		
G	0.257	0.262	DT8683	✓	✓	✓	✓		
H	0.375	0.380	DT8684	✓	✓	✓	✓		
I	0.490	0.510		.497	.501	.502	0.498		
J	1.174	1.184		1.180	1.180	1.180	1.179		
K	0.558	0.578		.567	.570	.573	0.570		
L	1.174	1.184		1.180	1.180	1.180	1.178		
M	1.490	1.500		1.497	1.496	1.495	1.498		
N	2.495	2.505		2.501	2.501	2.500	2.498		
O	3.869	3.879		3.873	3.874	3.872	3.874		
P	0.115	0.135		.125	.123	.125	0.123		
Q	0.115	0.135		.135	.135	.135	0.135		
R	0.240	0.260		.247	.247	.247	0.247		
S	0.115	0.135		.124	.125	.124	0.124		
T	0.178	0.198		.188	.188	.188	.188		
U	2.940	2.980		2.963	2.963	2.962	2.964		
V	0.230	0.250		.236	.236	.236	0.234		
W	0.115	0.135		.123	.125	.124	0.122		
X	0.308	0.313		0.311	0.311	0.312	0.312		
Y	0.760	0.765		0.761	0.761	0.761	0.761		
Z	0.352	0.372		.356	.357	.360	0.363		
AA	0.470	0.530		.500	.500	.500	.500		
AB	0.615	0.635		.629	.627	.631	0.624		
AC	0.053	0.073		.063	.063	.063	.063		
AD	0.240	0.260		.248	.247	.250	0.249		
AE	1.375	1.395		1.386	1.386	1.380	1.385		
AF	0.115	0.135		.135	.135	.125	0.135		
AG	0.240	0.280		.250	.255	.255	0.254		
AH	0.240	0.260		.248	.247	.247	0.248		
AI	2.000	2.020		2.004	2.004	2.004	2.000		
AJ	0.023	0.043		.03	.03	.03	.03		
Accept/Reject									

Measured by:	M8, 156.
Date:	06/01/22

Audited by:	
Date:	

Rev	Date	Change	Revised by	Approved
A		New Issue	RF	
B	02.09.24	Re-format; Added Rev. D	KJ	
C	02.10.11	Re-format; Added DT8682, DT8683, DT8684	KJ	
D	05.05.05	Added dimension AI	KJ/RF	
E	05.12.05	Added dimension AJ	KJ/JLM	

RELEASED

DART AEROSPACE LTD	Work Order: 24837
Description: Saddle, Fwd Outboard	Part Number: D2571
Inspection Dwg: D2571 Rev. E	Page 1 of 1

Inspect dimensions highlighted on inspection sheet drawing D2571 Rev. E and record below:

				Recorded Actual Dimensions					
Dim	Min	Max	Go/No Go Gauge	1	2	3	4	By	Date
A	0.438	0.443	DT8682	✓	✓	✓	✓		
B	1.745	1.755		1.750	1.751	1.750	1.750		
C	3.495	3.505		3.499	3.501	3.501	3.501		
D	1.745	1.755		1.751	1.750	1.750	1.750		
E	7.990	8.010		8.003	8.002	8.003	8.001		
F	0.490	0.510		0.501	0.502	.506	.504		
G	0.257	0.262	DT8683	✓	✓	✓	✓		
H	0.375	0.380	DT8684	✓	✓	✓	✓		
I	0.490	0.510		0.501	0.500	.505	.504		
J	1.174	1.184		1.179	1.180	1.180	1.180		
K	0.558	0.578		0.568	0.569	.571	.569		
L	1.174	1.184		1.180	1.180	1.180	1.180		
M	1.490	1.500		1.494	1.493	1.495	1.497		
N	2.495	2.505		2.500	2.494	2.500	2.500		
O	3.869	3.879		3.874	3.873	3.873	3.873		
P	0.115	0.135		0.123	0.126	.124	.124		
Q	0.115	0.135		0.134	0.135	.135	.135		
R	0.240	0.260		0.250	0.252	.248	.248		
S	0.115	0.135		0.124	0.123	.123	.123		
T	0.178	0.198		0.188	0.188	.188	.188		
U	2.940	2.980		2.961	2.962	2.963	2.964		
V	0.230	0.250		0.246	0.247	.238	.238		
W	0.115	0.135		0.119	0.120	.122	.123		
X	0.308	0.313		0.311	0.316	.310	.310		
Y	0.760	0.765		0.761	0.760	.762	.762		
Z	0.352	0.372		0.362	0.362	.362	.363		
AA	0.470	0.530		0.500	0.500	.500	.500		
AB	0.615	0.635		0.629	0.630	.633	.632		
AC	0.053	0.073		0.063	0.063	.063	.063		
AD	0.240	0.260		0.252	0.255	.246	.246		
AE	1.375	1.395		1.385	1.381	1.386	1.385		
AF	0.115	0.135		0.134	0.135	.135	.135		
AG	0.240	0.280		0.262	0.263	.260	.260		
AH	0.240	0.260		0.251	0.252	.252	.251		
AI	2.000	2.020		2.000	2.000	2.003	2.003		
AJ	0.023	0.043		0.033	0.033	.030	.030		
Accept/Reject									

Measured by: <u>J.G. / M8</u>
Date: <u>06/01/05</u>

Audited by:
Date:

Rev	Date	Change	Revised by	Approved
A		New Issue	RF	
B	02.09.24	Re-format; Added Rev. D	KJ	
C	02.10.11	Re-format; Added DT8682, DT8683, DT8684	KJ	
D	05.05.05	Added dimension AI	KJ/RF	
E	05.12.05	Added dimension AJ	KJ/JLM	

RELEASED
11-10-07

DART AEROSPACE LTD	Work Order:	24837
Description: Saddle, Fwd Outboard	Part Number:	D2571
Inspection Dwg: D2571 Rev. E		Page 1 of 1

Inspect dimensions highlighted on inspection sheet drawing D2571 Rev. E and record below:

				Recorded Actual Dimensions					
Dim	Min	Max	Go/No Go Gauge	1	2	3	4	By	Date
A	0.438	0.443	DT8682	✓	✓	✓	✓		
B	1.745	1.755		1.750	1.748	1.750	1.750		
C	3.495	3.505		3.500	3.500	3.500	3.499		
D	1.745	1.755		1.750	1.750	1.750	1.750		
E	7.990	8.010		8.002	8.003	8.002	8.002		
F	0.490	0.510		.502	.502	.503	.504		
G	0.257	0.262	DT8683	✓	✓	✓	✓		
H	0.375	0.380	DT8684	✓	✓	✓	✓		
I	0.490	0.510		.501	.506	.502	.500		
J	1.174	1.184		1.180	1.180	1.180	1.180		
K	0.558	0.578		.568	.567	.567	.568		
L	1.174	1.184		1.180	1.180	1.180	1.180		
M	1.490	1.500		1.494	1.496	1.495	1.494		
N	2.495	2.505		2.500	2.502	2.500	2.500		
O	3.869	3.879		3.873	3.873	3.871	3.873		
P	0.115	0.135		.125	.124	.123	.123		
Q	0.115	0.135		.135	.135	.135	.135		
R	0.240	0.260		.246	.246	.245	.248		
S	0.115	0.135		.123	.123	.124	.125		
T	0.178	0.198		.188	.188	.188	.188		
U	2.940	2.980		2.963	2.963	2.960	2.960		
V	0.230	0.250		.243	.240	.238	.241		
W	0.115	0.135		.120	.121	.121	.122		
X	0.308	0.313		.310	.310	.310	.310		
Y	0.760	0.765		.762	.762	.762	.762		
Z	0.352	0.372		.362	.362	.360	.361		
AA	0.470	0.530		.500	.500	.500	.500		
AB	0.615	0.635		.630	.630	.628	.630		
AC	0.053	0.073		.063	.063	.063	.063		
AD	0.240	0.260		.245	.247	.248	.249		
AE	1.375	1.395		1.385	1.385	1.384	1.385		
AF	0.115	0.135		.135	.135	.135	.135		
AG	0.240	0.280		.260	.260	.260	.260		
AH	0.240	0.260		.249	.249	.248	.249		
AI	2.000	2.020		2.005	2.005	2.005	2.002		
AJ	0.023	0.043		.030	.030	.030	.030		
Accept/Reject									

Measured by:	M8
Date:	06/01/26

Audited by	
Date:	

Rev	Date	Change	Revised by	Approved
A		New Issue	RF	
B	02.09.24	Re-format; Added Rev. D	KJ	
C	02.10.11	Re-format; Added DT8682, DT8683, DT8684	KJ	
D	05.05.05	Added dimension AI	KJ/RF	
E	05.12.05	Added dimension AJ	KJ/JLM	

RELEASED
11/02/2026